

Work Order ID 48498

Page 1

Friday, June 26, 2009 8:56:42 AM

Item ID: D3213-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Door Panel

Start Date: 7/15/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3213	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

A
A

0.00

HB 9-7-2

FLOW CNC Waterjet

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

- 8026762 (410)

(10)

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.

3. The third step is to develop a plan or strategy to address the problem. This involves identifying the resources needed, the tasks to be completed, and the timeline for the project.

4. After the plan is developed, the next step is to implement the plan. This involves putting the plan into action and monitoring progress to ensure that the objectives are being met.

5. Finally, the last step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and identifying any lessons learned for future projects.

Friday, June 26, 2009 8:56:42 AM

Accept

[illegible]**Setup Start**

[REDACTED]

Stop

[illegible][illegible]**Cust Item ID:**

Start Date: 7/15/2009 **Start Qty:** 10.00

Required Date: 8/3/2009 Req'd Qty: 10.00

Customer:

Reference:

Run Start

[illegible]

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

[illegible]

Small Fab

0.00

0.00

Small Fab

Memo

Small Fab

Deburr

140

[illegible]

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

150

1. The first step is to identify the problem or question that needs to be addressed. This involves understanding the context and the specific requirements of the task.

2. Next, it is important to gather relevant information and data. This can be done through research, consultation with experts, or by analyzing existing data sets.

3. Once the information is gathered, the next step is to analyze it. This involves identifying patterns, trends, and potential solutions. It is important to consider all possible options and weigh their pros and cons.

4. After analysis, a decision must be made. This should be based on the available information and the goals of the project. It is important to communicate the decision to all relevant parties.

5. Finally, the decision must be implemented. This involves putting the chosen solution into action and monitoring its progress. It is important to be flexible and willing to make adjustments as needed.

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

Work Order ID 48498

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Item ID: D3213-3

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Setup Start



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Stop



Item Name: Door Panel

Start Date: 7/15/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>233</u>	0.00							
Packaging	Memo	0.00				9/7/6		(10x)	SP
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/07/07

6 09.07.07

Picklist Print

Page 1

Friday, June 26, 2009 8:56:41 AM

Work Order ID: 48498



Parent Item: D3213-3RevA



Parent Item Name: Door Panel



Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063  2024-T3 .063 sheet		Purchased	No			100	sf	0.0000	4.9621 			

m 111787 AB 9-7-2

Date: Thursday, 11/06/2009 11:55:55 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR ASSEMBLY
Job Number : 48498	
Estimate Number : 10712	
P.O. Number :	Part Number : D32133
This Issue : 11/06/2009 S.O. No. :	Drawing Number : D3213 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 44233	Material :
Written By :	Due Date : 19/06/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 09.06.11</u>	
Comment : Est Rev:A New Issue 05-11-17 JLM	
Est Rev:B Now on Waterjet 07-02-13 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.4950 sf(s)/Unit Total: 4.9497 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063)Identify as D3213-3
 Batch: 111707 IB 9-7-2

2.0	WATER JET	FLOW WATER JET
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A
AIB 9-7-2**Comment:** FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 9-7-2**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKS 05/07/02 @

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr IB 9-7-2

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/06/2009 11:55:55 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 48498

Part Number: D32133

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 48498
Description: Door Panel		Part Number: D3213-3
Inspection Dwg: D3213	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.00	+/-0.030	15.00	*			
0.300	+/-0.010	.300	*			
14.400	+/-0.010	14.400	*			
Ø0.128	+0.005/-0.001	.129	*			
4.42	+/-0.030	4.424	*			
1.00	+/-0.030	.997	*			
0.300	+/-0.010	.301	*			
Pitch 2.057	+/-0.005	2.058	*			
10.63	+/- .010	10.62	*			

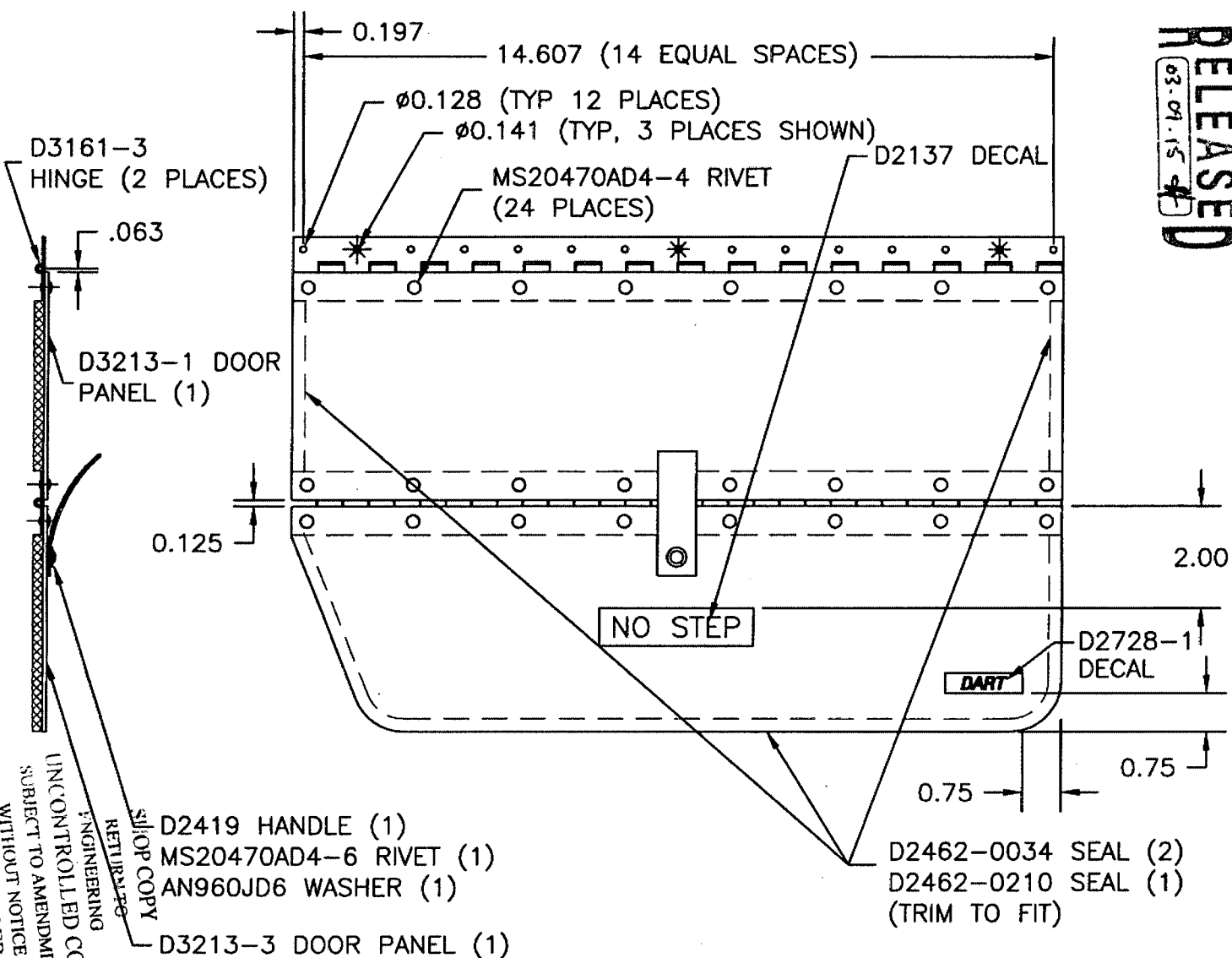
Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 97-2	Date: 09/07/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	04.06.15	Tolerance changed for 14.400 dimension	KJ/JLM	
C	08.11.27	Diameter symbol added to dimension 0.128	KJ/EC	



DESIGN	CH	DRAWN BY	CH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	APPROVED	✓	DRAWING NO. D3213
DATE	03.09.03	TITLE	DOOR ASSEMBLY	REV. A 1 OF 2
A	03.09.03	NEW ISSUE		SCALE 1:3

RELEASED
03-09-15



D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

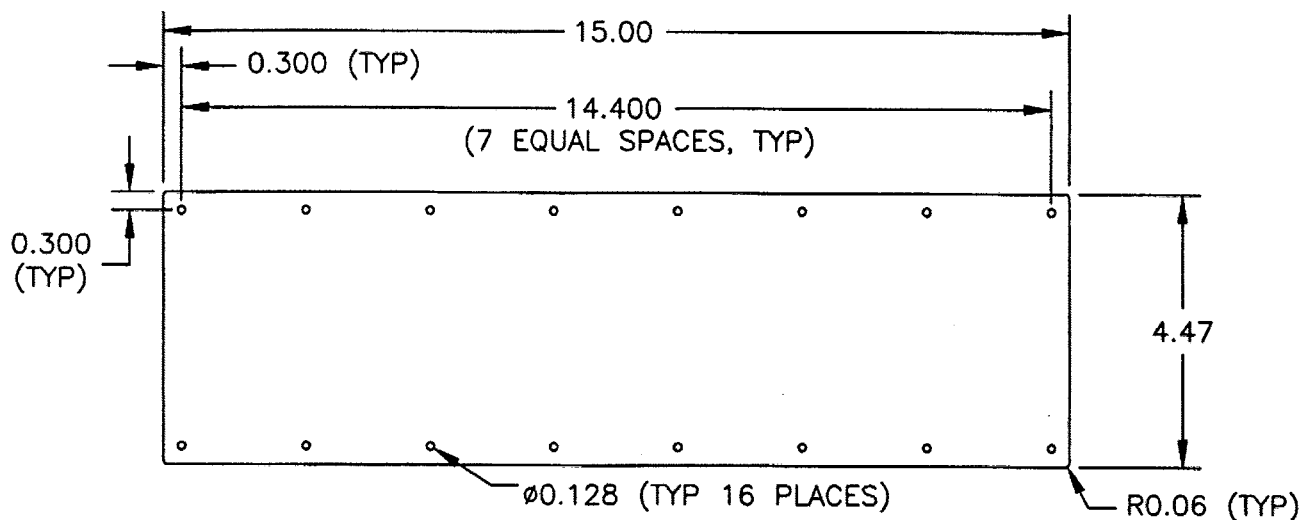
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

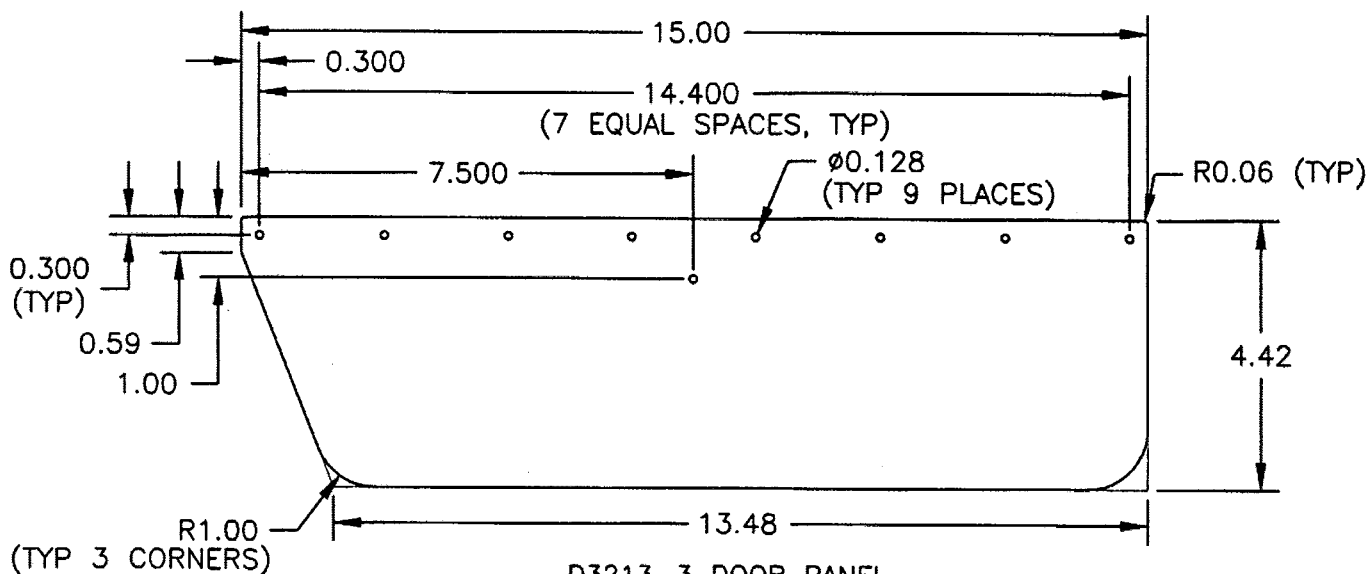
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03 09 15

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48498

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